

Work Order ID 72416

Monday, July 25, 2011 11:53:56 AM



Page 1

Item ID:	D3508-5	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearplate				Stop	
Start Date:	7/25/2011	Start Qty: 8.00		Cust Item ID:		
Required Date:	7/29/2011	Req'd Qty: 8.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	7-27-11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3508	Rev C

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3508 <input type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog Rev: <u>C</u> <input type="checkbox"/> 2-								
304.040	Deburr if necessary								

B11-8-9

(12)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-8-9

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

5 ulos 109

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

Item ID: D3508-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 7/25/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 d 11/10/15

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

12x 4 m 11/10/15

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/15

MF 11-08-15

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, July 25, 2011 11:54:02 AM

Page 1

Work Order ID: 72416



Parent Item: D3508-5



Parent Item Name: Wearplate


Start Date: 7/25/2011

Required Date: 7/29/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
 IPP Rev:B Now SS as per Rev B 06-12-15 JLM
 IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	283.1072	0.6187	5.210105	7.5		



B119-8

Location

Loc Qty

Loc Code

MAT020

283.1072

116623

0.2

117550

9.363

117933

81.5442

118400

192

118400

(12)

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DART AEROSPACE LTD		Work Order:	72416
Description: Wearplate		Part Number:	D3508-5
Inspection Dwg: D3508	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.068	✓		V IB02	
2.813	+/-0.010	2.810	✓		V	
0.375	+/-0.010	.373	✓		V	
5.625	+/-0.010	5.625	✓		T IB01	
28.125	+/-0.010	28.125	✓		T	
31.62	+/-0.030	31.62	✓		T	
Ø0.188	+0.005/-0.001	.191	✓		V	
0.300	+/-0.010	.304	✓		V	
0.300	+/-0.010	.306	✓		V	
0.038	+/-0.010	.037	✓		V	

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 11-9-8	Date: 11/02/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/EC	AF

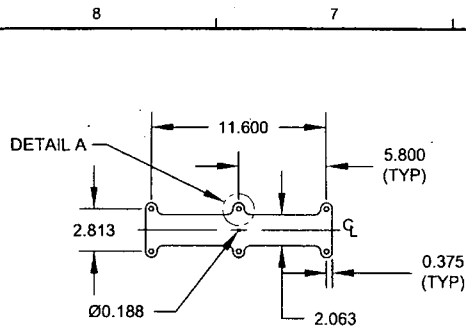
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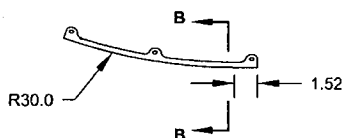
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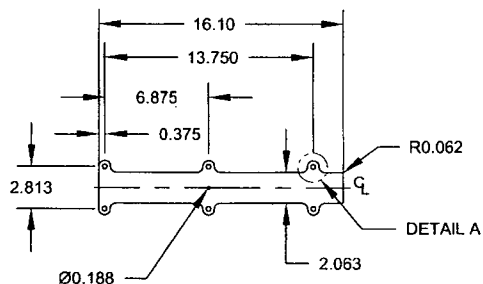
NOTE: Date & initial all entries



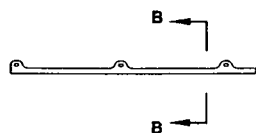
D3508-1 FLAT PATTERN



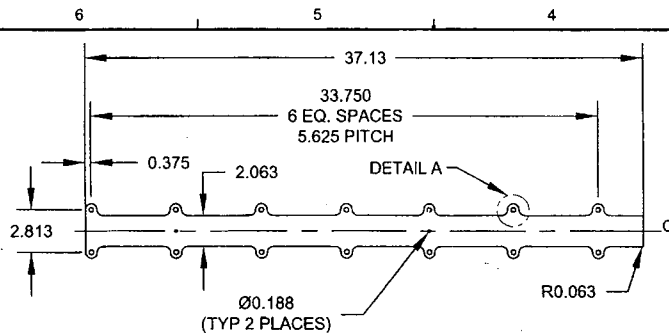
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



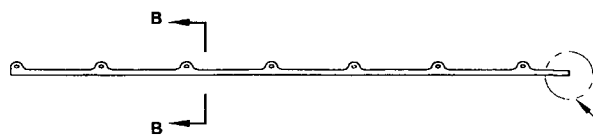
D3508-7F FLAT PATTERN



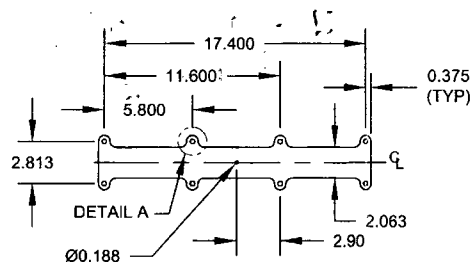
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(MAKE FROM D3508-7F)



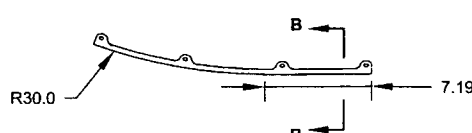
D3508-3 FLAT PATTERN



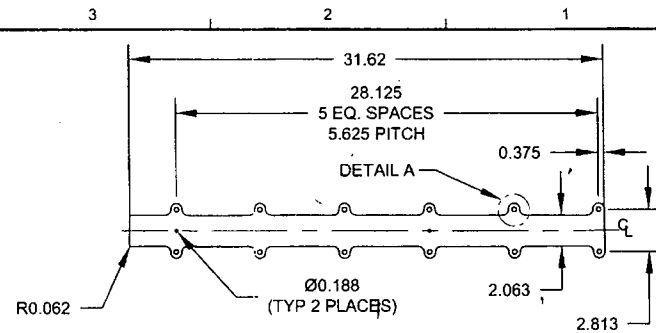
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



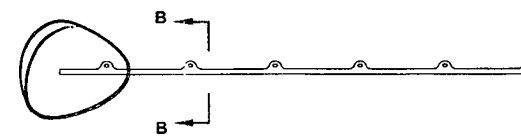
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07-11-16

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED
SUBJECT TO AMEND
WITHOUT NOTICE
WORK ORDER
NO. 72416

C	ADD -9/11/13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.04.20		
DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3508 TITLE WEARPLATE SCALE 1:8 REV. C SHEET 1 OF 2 COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

11-07-25

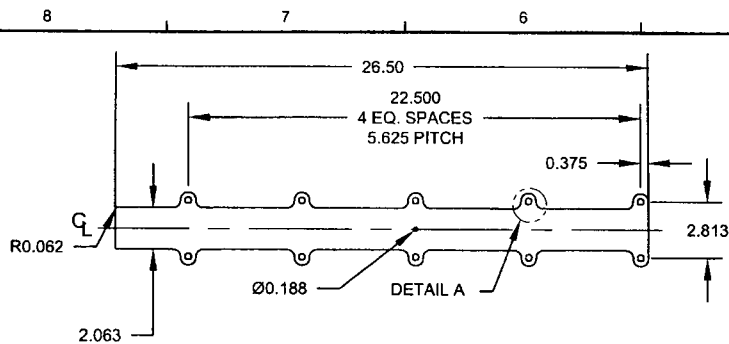
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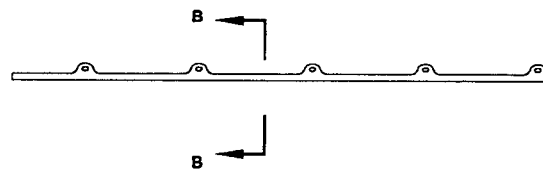
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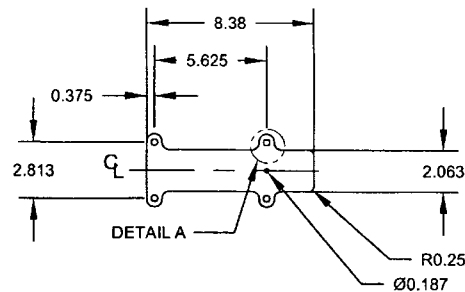
NOTE: Date & initial all entries



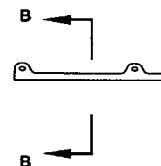
D3508-11F FLAT PATTERN



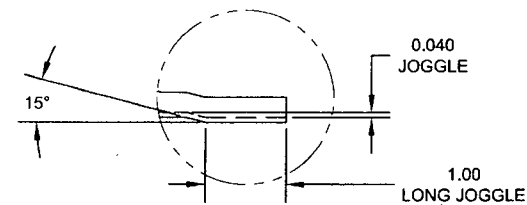
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



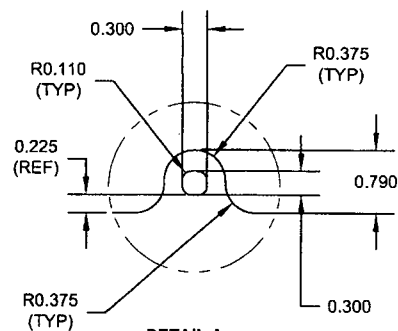
D3508-13F FLAT PATTERN



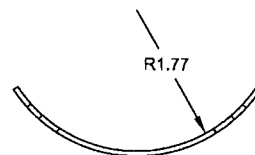
D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



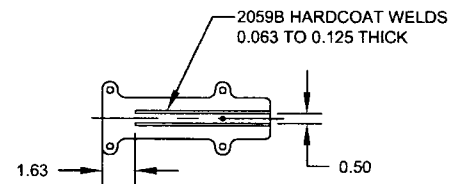
DETAIL C
(SCALE 1:2)



DETAIL A
(SCALE 2:3)



SECTION B-B
(SCALE 2:3)



D3508-13 WELDING DETAIL

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	
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